

WPI

TI - Prodn. of biaxially oriented resin film for shrink packaging - in which air is blown into thermoplastic resin bubble for inflation moulding, and the film obtd. is folded into two parts and drawn

AB - J08039667 Air is blown into a thermoplastic resin bubble formed by melt extrusion moulding through a ring die (d), for inflation moulding in the condition of (b)/(a) of 1.5-10 where (a) is the dia. of a bubble made of the thermoplastic resin at its crystallisation temp. and (b) is the final dia. of the inflated bubble. The inflated, oriented film is folded into two parts, and drawn 1.2-5 times in the longitudinal direction, using the circumferential speed difference between a group of nip rolls (18,19).
 - USE - The film is useful for shrink packaging.
 - ADVANTAGE - A film having high heat shrinkage properties can be formed with high heat efficiency.
 - (Dwg.1/9)

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PR - JP19940180316 19940801

PA - (MITU) MITSUBISHI CHEM CORP

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PAJ

TI - PRODUCTION OF BIAXIALLY STRETCHED RESIN FILM

AB - PURPOSE: To obtain a biaxially stretched film excellent in heat shrinkability by applying longitudinal stretching to a bubble over a short section by nip rolls in addition to the stretching of the bubble due to air in longitudinal and lateral directions.
 - CONSTITUTION: Air is blown in a thermoplastic resin bubble (e) extruded from an annular molding die (d) in a molten state. The bubble (e) is subjected to inflation molding under such a condition that b/a is 1.5-10 when the diameter of the bubble at the crystallizing temp. of the used thermoplastic resin is set to (a) and the final diameter of the expanded bubble is set to (b) to obtain an oriented film (f) which is, in turn, folded double. This oriented film (f) folded double is longitudinally stretched by 1.2-5 times by utilizing the peripheral speed difference between nip rolls 18,19. The blow ratio of the oriented film obtained by inflation molding is pref. 6-22 times. As the used thermoplastic resin, polyethylene, polypropylene, an ethylene/vinyl acetate copolymer, an ethylene/acrylic acid copolymer and the like are designated.

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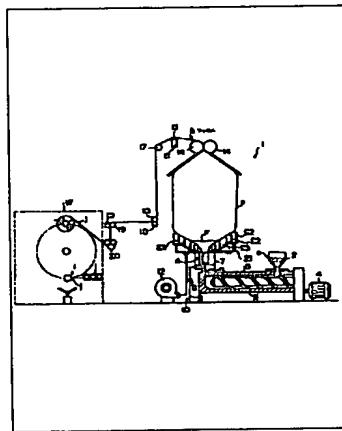
AP - JP19940180316 19940801

PA - MITSUBISHI CHEM CORP

IN - YAZAKI TAKAO; others: 04

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